Work Orde		6270		*106	3270*							Page 1	
Item ID: Revision ID: Item Name:	D4092-041  Maintenance S 8/28/13	Step Assembly Start Qty: 4.00 Req'd Qty: 4.00	, *4* *4*	Accept	*N900  Cust Item Customer	ı ID:	100	)* s	Setup S	Start Stop	171	S1* S2*	
Reference: Approvals:	Process Pla	in: MLゴ	Date: <u>\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\</u>	Tooling: _ SPC (Y/N):		Date:		F		Start Stop	*NI *NI	R1* R2*	
Sequence ID/ Work Center II	 )	Operation Description	·	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp	_
Draw Nbr	Rev	vision Nbr											
D4092	В												
100		Pick Kit		0.00									
*100* Packaging Packaging		Memo		0.00				34				13/10/DS	36 9-89
*110				0.00				3×				B lo L	/ DAS
Small Fab Small Fab			as per Dwg rews up to 15-25 in- lbs	0.00								<del>-</del> /-/-/-	DAS 36 9-89
120		QC5- Inspect part com	pleteness to step on W/O	0.00 Č	i <b>as</b>			3					
*120* QC Quality Control		Memo		0.00	188 27 10 10 10 25			<u> </u>					

												DQA:	Da	ite:	
NCR: Y	⁄es	/ No				WORK ORDER NON-C	CON	NFORM	AANCE / UP	DATE		OA Classic			
							_					QA Closed:	Da	ite:	
Work Orde	er:					DISPOSITION				AGAINST I	DΕ	PARTMENT	/PROCESS		
Part N	- No					Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube  Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		4	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update	l	nitial	Act	ion		Sign &			
Cause	Ì	Date	Step	Qty	c	or Non-conformance	Ch	ief Eng	Descr	iption		Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved															
		***				<del></del>	AUL	T CATE	SORY	· · · · · · · · · · · · · · · · · · ·		<u> </u>			
Landi		<b>ear</b> Bending				General Bend		Grain		ſ		Ovalized		Γ	Pressure/Forced
	-	Centre No	it Concer	ntric to (	n/s	BOM/Route	-	Hardwa	re	•		Over/Under	tolerance	-	Temperature/Cure
:	Н	Cracks	Conce	iti ie to	),	Broken/Damaged	_		on incomplete	•		Part Incorred			Weld
	П	Crushed/0	Crimped			Burrs	П	Instruct	ions Incomplete/U	Inclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance	ļ		Part Moved			-
		Heat Trea	t			Countersink		Mislabe	led			Positioned V	<b>Vrong</b>		
	$\Box$	Inspection	Strip in	Tube		Cut Too Short		Misread				Power Loss/:	Surge		Other
	П	Ripples in	Bend			Drill Holes		Offset		_		•			-

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

W	ork	Order	ID	106270
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\*106270\*

Page 2

August-28-13 12:41:19 PM Item ID: D4092-041 Accept \*N900040100\* Setup Start **Revision ID:** Maintenance Step Assembly Item Name: \*4\* Start Otv: 4.00 **Start Date:** 8/28/13 **Cust Item ID:** Required Date: 8/28/13 Req'd Qty: 4.00 \*/1\* Customer: Reference: Start Run **Tooling:** Date: Approvals: Process Plan: Date: Stop Date: SPC (Y/N): QC: Date: Operation Set Up/ Tool ID Tool # Plan Reject Reject Sequence ID/ Accept Insp. **Qty** Qty Number Stamp Work Center ID Description **Run Hours** Code Identify as per dwg & Stock Location: PPP 130 0.00 DAS 108166 \*130\* 33 0.00 Packaging 9-89 Memo Packaging

140

QC21- Final Inspection - Work Order Release

0.00

\*140\*

OC Quality Control

Memo

0.00

									DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	ONFO	RMANCE / U	PDATE	QA Closed:	Date:	
					DISPOSITION			AGAINST D	EPARTMENT		• .
Work Orde	er:	٠			Rework	1 <b> </b>	Skid-tube	Crosstube	7	Water Jet	Engineering
Part N				<del>.</del>	Scrap Use-as-is	The	Machiningermoforming	Small Fab Finishing	<b>⊣</b>	d. Eng. Coor. re/Packaging	Quality Other
NCR N	No				Work Order Update	]	Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Initia		Action	Sign &		
Cause	Date	Step	Qty	. (	or Non-conformance	Chief E	ng Des	scription	Date	Verification	QC Inspector
Doc/Data			:		,						
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Operator Material	-										
Material							1	٠.			
Setup Other											
Process	$\vdash$	1							•	·	
Supplier							·				
Training							·				
Unapproved		<u> </u>									
		1	1		. F	AULT CA	TEGORY		<b>L</b>		<u> </u>
Landi	ng Gear			116	General		1				
	Bending				Bend	Grai	n		Ovalized		Pressure/Forced
1.	Centre N	ot Conce	ntric to	o/s	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspe	ection Incomplete		Part Incorre	ct ,	Weld
,	Crushed/	Crimped			Burrs	Instr	uctions Incomplete	e/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mai	ntenance	<u>.</u>	Part Moved		-
	Heat Tre	at ·			Countersink	Misla	abeled		Positioned \	Vrong	_
	Inspection	n Strip in	Tube		Cut Too Short	Misr	ead		Power Loss/	Surge	Other
	Ripples ii	n Bend			Drill Holes	Offse	et	_			

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

August-28-13 12:41:22 PM

Work Order ID: 106270

\*106270\*

Parent Item:

D4092-041

\*D4092-041\*

Parent Item Name: Maintenance Step Assembly

**Start Date: 8/28/13** 

Required Date: 8/28/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP REV:A NEW ISSUE 10-06-01 JLM VERIFIED BY:DD

	REV:B AS PER E	CN 11-639 JLM \	/ERIFI	ED BY:DD									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1	,	Manufactured	No			100	Each	3.0000	2	8		1 /	DAS
*D4092-1 Maintenance Step	*								**		_B/	0/25	<b>36</b> 9-89
Waintenance Step				Location	 <u>1</u>	Loc	Oty	Loc Code			•		
				GA			1				- 0	•	
					77852		1		_		_ <b>B</b> ,	1078	203 (6
				ST241A			1				<u> </u>		
,					74303		1		_		-	÷	
		**		ST270A			1		_				DAS
					102366		l				_		36
D4093-1 *D4002 1	•	Manufactured	No			100	Each	2.0000	1	4	. –		9-89
<sup>୬</sup> *D4093-1	*								**		13,	110/25	
Bracket													
				<u>Location</u>	<u>1</u>	Loc	: Qty	Loc Code			I	3/08	10/
				ST270	,		2		_		$_{-}$ $_{\mathcal{F}}$	5/00	ك)) 7 ا
				•	99653	•	2		_				
D4093-3		Manufactured	No			100	Each	8.0000	. 1	4		<i>J</i> -	/ Das
`*D4093-3	*								**		1.	3/10	/2 C 26
Bracket			•	,					. ' -				25 <b>36</b>
				Location	<u>1</u>	Loc	<u>Oty</u>	Loc Code				_	
				ST270			8				_ /	2108	2025
					102880	•	8				_ ~		~∪न् ऽ

IPP

									DQA:	Date:	
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	-				1	<del>- ,</del>			QA Closed.	Date.	
Work Orde	, rè				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
WOIK OIGE					Rework	ı: <b>İ</b>	Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	lo.				Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
				ů.	Use-as-is	The	rmoforming	Finishing	4	re/Packaging	Other
NCR N	lo				Work Order Update		Large Fab	Composite		Supplier	
Doct		T	1 1	Dosori	ption of work order update	Initial	1 ^	ction	Sign &		T
Root Cause	Date	Step	Qty		or Non-conformance	Chief Er		cription	Date	Verification	QC Inspector
Doc/Data	Date	Steh	Qty	•	or Non-comormance	Cinei Li	ig Des	cription	Date	Verification	QC Inspector
Equip/Tooling											
Operator											
Material											
Setup											
Other •	=										
Process									, i		
Supplier											
Training •											
Unapproved											
					· F <sub>i</sub>	AULT CAT	EGORY				
Landir	ng Gear				General						_
ĺ	Bending				Bend	Grain	ı		Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to (	o/s	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure
	Centre Not Concentric to O/S Cracks				Broken/Damaged	Inspe	ction Incomplete		Part Incorre	ct	Weld
	Crushed	Crimped			Burrs	Instru	ictions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mair	tenance		Part Moved	<u></u>	_
	Heat Treat				Countersink	Misla	beled		Positioned V	Vrong	_
	Inspection	Heat Treat Inspection Strip in Tube			Cut Too Short	Misre	ead		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

August-28-13 12:41:22 PM

\*106270\* Work Order ID: 106270 D4092-041 \*D4092-041\* Parent Item: **Start Date: 8/28/13** Required Date: 8/28/13 Parent Item Name: Maintenance Step Assembly Required Qty: 4.00 Start Oty: 4.00 100 4.0000 Manufactured Each DAS \*\* Loc Code Location Loc Qty ST093 102780 516,0000 2 100 MS24694-S54 No Each Purchased \*\* \*MS24694-S54\* **SCREW** Location Loc Qty Loc Code ST303 516 516 125535 100 Each 119.0000 32 No MS24694-S55 Purchased \*\* 24694-555\* Loc Code Location Loc Qty ST303 119 61 124296 125535 -58 167.0000 MS24694-S56 No 100 Each Purchased \*\* **SCREW** Loc Code Location Loc Qty ST303 167 10 121340 125535 57 100 m126400

							٠				DQA:	Dat	te:	,
NCR: \	⁄es	/ No				WORK ORDER NON-O	COI	NFORM	ANCE / UP	DATE				
									-		QA Closed:	Dat	te:	
Mort Orde	. <u>.</u> .					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Work Orde	er: -					Rework	٦		Skid-tube	Crosstube	]	Water Jet	7	Engineering
Part N	No.					Scrap		ſ	Machining	Small Fab	1	d. Eng. Coor.	<u></u>	Quality
						Use-as-is	]		noforming	Finishing	Rec/Sto	re/Packaging	_	Other
NCR N	۷o.	-,				Work Order Update	]		Large Fab	Composite		Supplier		. 📙
	1	-, , ,	· ·								G: 0	<u> </u>	-	-
Root		5.	6.			ption of work order update	1	Initial		tion	Sign &	Manifiantian		06 Imama atau
Cause	_	Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desc	ription	Date	Verification	-	QC Inspector
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Equip/Tooling	Н													
Operator	Н		İ				1							
Material	Н						İ						ŀ	
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Process	Н		ļ								:			
Supplier	Н													
Training Unapproved	Н													
Unapproved	1		1				ΔΗ	LT CATE	GORY			<u> </u>		
Landi	na G	ear				General		LI CATE	30111			·-		
Land	$\overline{}$	Bending				Bend		Grain			Ovalized	Г	P	ressure/Forced
		Centre N	ot Conce	ntric to O	1/5	BOM/Route	$\vdash$	Hardwa	re	<del></del>	Over/Under	tolerance	_	emperature/Cure
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	$\vdash$	Crushed/	Crimped			Burrs		<b>-</b>	ions Incomplete/	Unclear	Part Lost/Mi	- F		/rong Stock Pulled
	$\boldsymbol{\vdash}$	Cuffs				Contamination		Mainte			Part Moved	~ L		
	H	Heat Trea	at			Countersink		Mislabe			Positioned V	Vrong		
	П	Inspectio		Tube		Cut Too Short	一	Misread			Power Loss/	· ·	По	ther
	П	Ripples in	-		-	Drill Holes		Offset	•	<b>-</b>	•	- L		

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

43

335 1383

912

471

5000 1000

4000

123265

123900

124291

M126275 M126333

ST506

ST510a

M126036

												DQA:	D	ate:	
NCR:	Yes	/ No				<b>WORK ORDER NON-</b>	CO	NFORM	MANCE / UP	DATE					
												QA Closed:	D	ate:	
Work Ord	oř.					DISPOSITION				AGAINST D	ÞΕ	PARTMENT,	/PROCESS		
WOIK OIG	C1.				<u> </u>	Rework	٦		Skid-tube	Crosstube			Water Je	t	Engineering
Part I	No.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coo		Quality
	•					Use-as-is		Therm	noforming	Finishing		Rec/Sto	re/Packagin	g	Other
NCR I	No.					Work Order Update			Large Fab	Composite			Supplie	r	
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Cause		Date	Step	Qty	(	or Non-conformance	Ct	nief Eng	Desc	ription		Date	Verificati	on -	QC Inspector
Doc/Data			1												
Equip/Tooling															
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Other															
Process															
Supplier															
Training															
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		Bending				Bend		Grain				Ovalized			Pressure/Forced
}		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorred	ct		Weld
		Crushed/	'Crimped			Burrs		Instruct	ions Incomplete/	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance	Γ		Part Moved			-
		Heat Trea	at			Countersink	Г	Mislabe	led	Γ		Positioned V	Vrong		
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	İ	Γ		Power Loss/	Surge		Other
		Ripples in	n Bend			Drill Holes		Offset		_					

Out of Calibration Out of Sequence

Outside Dimensions

Turning Sequence

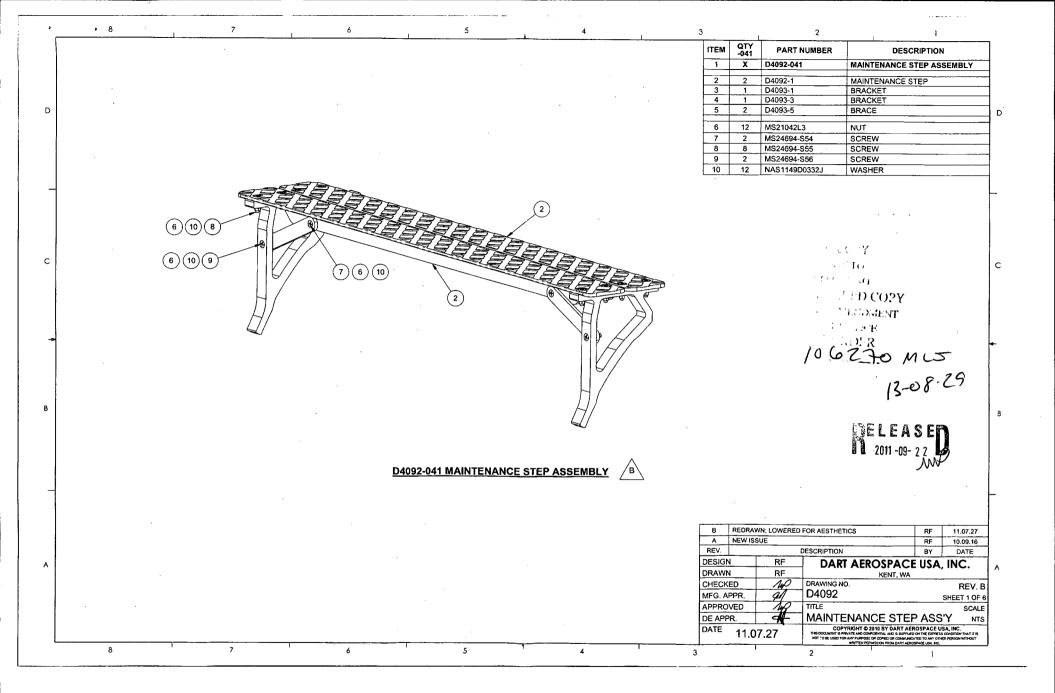
Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drawing

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



												DQA:	D	ate:	
NCR: Y	'es	/ No				WORK ORDER NON-O	100	NFOR	MANCE / UP	DATE					
		_						_				QA Closed:	D	ate:	
Work Orde	٠					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
Work Orde	-					Rework	1		Skid-tube	Crosstube	_	Ī	Water Je	t∏	Engineering
Part N	lo.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor	$\vdash$	Quality
	-					Use-as-is	]	Thern	noforming	Finishing		Rec/Sto	re/Packaging		Other
NCR N	10				<del></del>	Work Order Update	]		Large Fab	Composite		]	Supplie	r	
Root	Т				Descri	tion of work order update		Initial	Ac	tion		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	on	QC Inspector
Doc/Data							Г								
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[		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance			Part Moved			

Mislabeled

Out of Calibration
Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

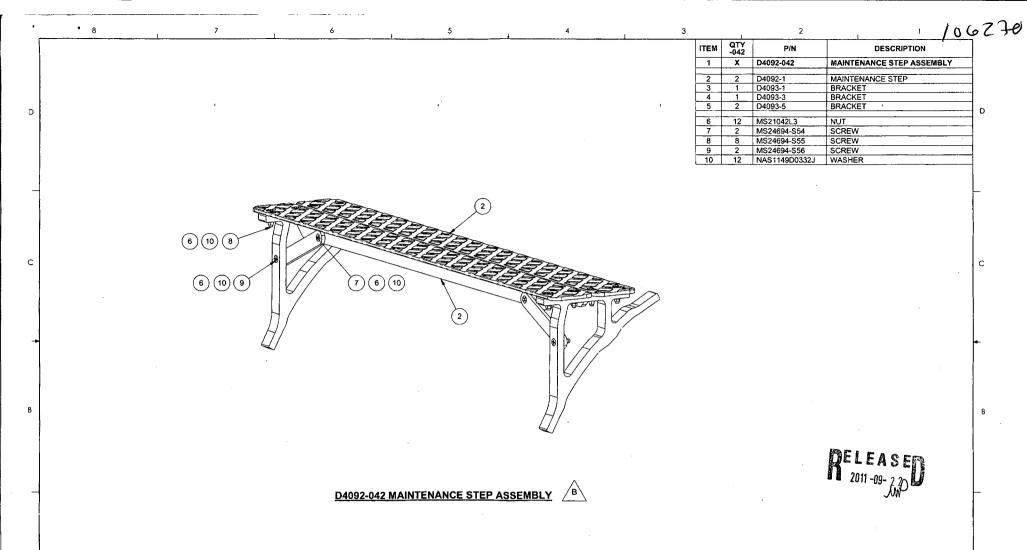
Countersink

Cut Too Short

Drill Holes

Drawing

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

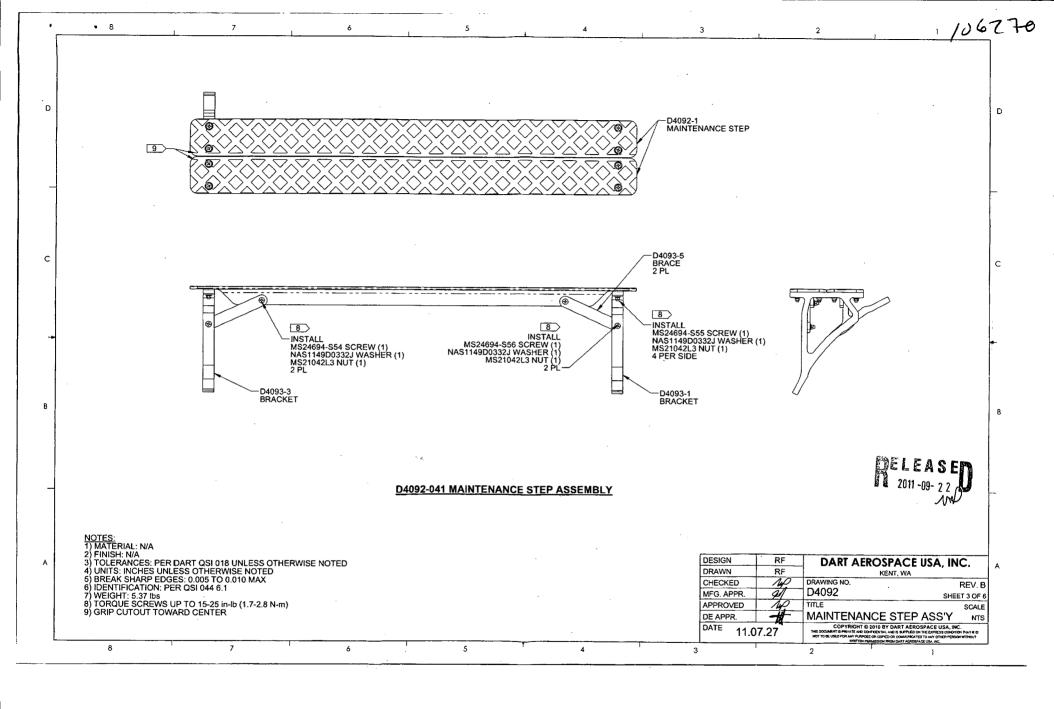


DESIGN DART AEROSPACE USA, INC. RF DRAWN DRAWING NO. D4092 140 CHECKED REV. B MFG. APPR. SHEET 2 OF 6 TITLE APPROVED SCALE MAINTENANCE STEP ASS'Y DE APPR. NTS DATE 11.07.27

3

Nork Ordor	DISPOSITION	AGAINST DEPARTMENT/PRO	OCESS	
		QA Closed:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFOR	MANCE / UPDATE		
		DQA:	Date:	

Work Orde	ir.				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
					Rework			Skid-tube Machining	Crosstube Small Fab	Dro	Water Jet	Engineering Quality
Part N		<del></del>			Scrap	۱,			<u> </u>	<b>—</b>		Other
NCR N					Use-as-is Work Order Update	'		noforming Large Fab	Finishing Composite	- Rec/310	re/Packaging Supplier	— —
NCK N					work Order Opdate	'		carge rab	composite		Jappiiei	┙ し.
Root				Descri	ption of work order update	Init	ial	Act	tion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chief	Eng	Desci	ription	Date	Verification	n QC Inspector
Doc/Data												
Equip/Tooling											,	
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Other			<u> </u> -			1						
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Landir	ng Gear				General					_		·
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	Centre	Not Conce	ntric to	o/s	BOM/Route	L Hа	ardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	lns	specti	on incomplete		Part Incorre	ct	Weld
	Crushe	d/Crimped			Burrs	lns	structi	ions Incomplete/l	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Шм	ainte	nance		Part Moved		
	Heat Tr	eat		L	Countersink	Шм	islabe	led		Positioned \	Wrong	
	Inspect	ion Strip ir	Tube		Cut Too Short	Шмі	isread	ļ		Power Loss,	'Surge	Other
	Ripples	in Bend			Drill Holes	Of	fset					
	Torque	Waves in	Extrusio	n 🗌	Drawing	∐oı	ut of C	Calibration				
[	Turning Sequence Finish Out of Sequence											
[	IMayo!	Twict in Tu	ho		Folio	I lo.	itcido	Dimensions				



											DQA:	Date:	
NCR: Ye	es / No				WORK ORDER NON-	COI	NFORI	MANCE / UP	PDATE		QA Closed:	Date:	
					DISPOSITION				AGA	NINST DE	PARTMENT		
Work Order	•				i	7	Ì				7	·	, ,
					Rework	4	ł	Skid-tube		stube	-	Water Jet	Engineering
Part No	D				Scrap	4		Machining		II Fab	4	d. Eng. Coor.	Quality
					Use-as-is	4	Thern	noforming		shing	Rec/Sto	re/Packaging	Other
NCR No	o				Work Order Update	J		Large Fab	Comp	osite	1	Supplier	
Root				Descri	ption of work order update	Τ	Initial	Ac	ction		Sign &		
Cause	Date	Step	Qty	,	or Non-conformance	Cł	nief Eng	Desc	cription		Date	Verification	QC Inspector
Doc/Data		ļ			<u> </u>								
Equip/Tooling													
Operator		1											
Material										•			:
Setup			1						4				<u> </u>
Other													
Process						1							,
Supplier										-		Ì	:
Training													:
Unapproved													·
					F	AUI	LT CATE	GORY					·
Landing	g Gear				General		_				-	_	-
	Bending			L	Bend		Grain				Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to O	)/s	BOM/Route		Hardwa	ire			Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspect	ion Incomplete			Part Incorre	ct	Weld
1	Crushadi	Crimned		1	Rurre		Instruct	ions Incomplete	/Unclear		Part Lost/Mi	iccing	Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Ripples in Bend

Turning Sequence

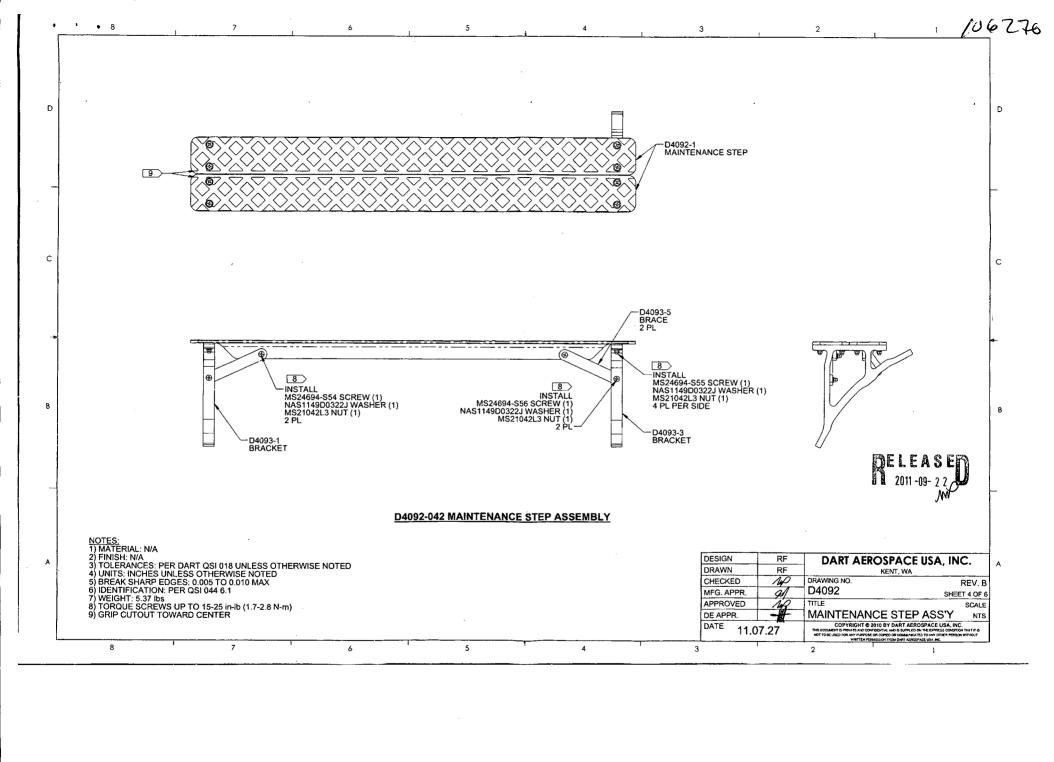
Wave/Twist in Tube

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion



											DQA:	Date	e:	
NCR: Y	'es /	No				WORK ORDER NON-C	O	<b>IFOR</b>	MANCE / UP	DATE	QA Closed:	 Dat		
					·· ·· ·· ·	·	-				QA Closed:	Date	e	
Work Orde	»ŕ·					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part N	 lo					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other	
											Cian 0			
Root		1 1 1			iption of work order update or Non-conformance		Initial Action hief Eng Description			Sign & Date	Verification	QC Inspector		
Cause Doc/Data	100	ate	Step	Qty		or won-comormance	Cit	ief Eng	Desc	прион	Date	vermeation	QC IIISPECTOI	
Equip/Tooling	$\dashv$											1		
Operator	$\dashv$	1												
Material	$\dashv$						1							
Setup	1				·									
Other														
Process		1												
Supplier		1												
Training														
Unapproved														
						F	AUL	T CATE	GORY					
Landi	ng Gear					General		•			-		, , , , , , , , , , , , , , , , , , ,	
	Bending					Bend		Grain			Ovalized	L	Pressure/Forced	
	Centre Not Concentric to O/S					BOM/Route		Hardware			Over/Under tolerance		Temperature/Cure	
	Cracks					Broken/Damaged		Inspection Incomplete			· —		Weld	
			rimped			Burrs	Ŀ	Instructions Incomplete/Unclear			Part Lost/Mi	Wrong Stock Pulled		
	Cuffs					Contamination		Mainte			Part Moved			
	Heat Treat					Countersink		Mislabe		<u> </u>	Positioned V		_	
	<b>⊢</b>		Strip in	Tube	<u> </u> _	Cut Too Short		Misread	i		Power Loss/	Surge	Other	
	——	oles in I				Drill Holes	$\perp$	Offset						
	Torque Waves in Extrusion					Drawing	1	Out of 0	Calibration					

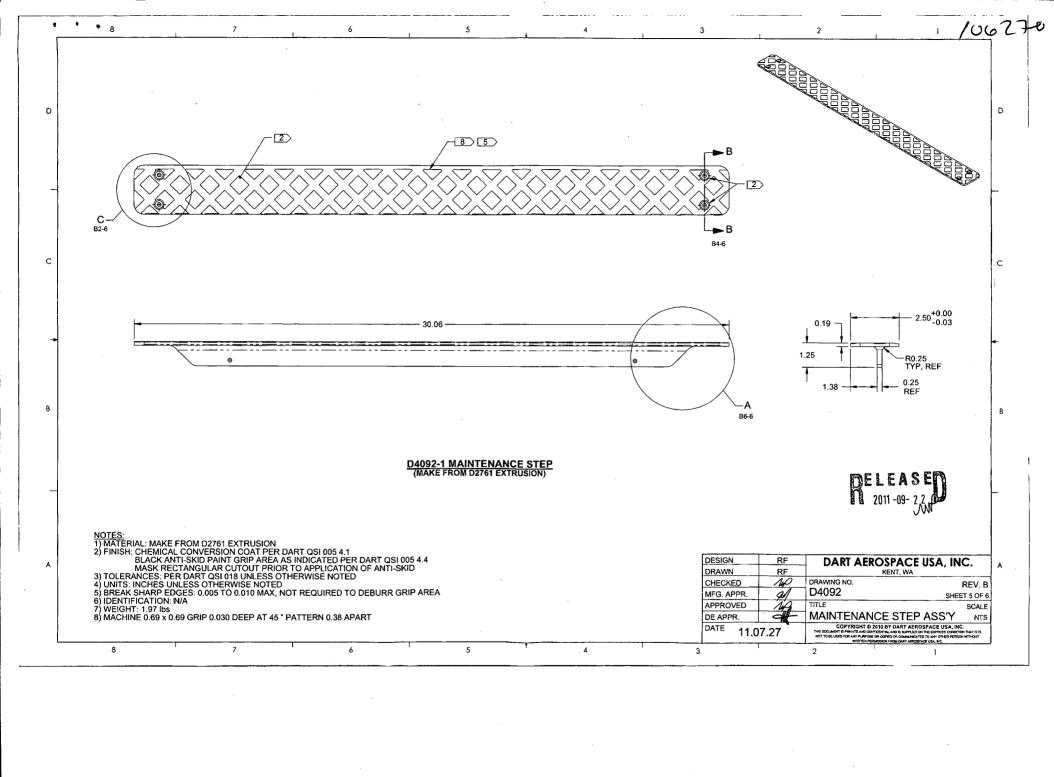
Out of Sequence

Outside Dimensions

Turning Sequence

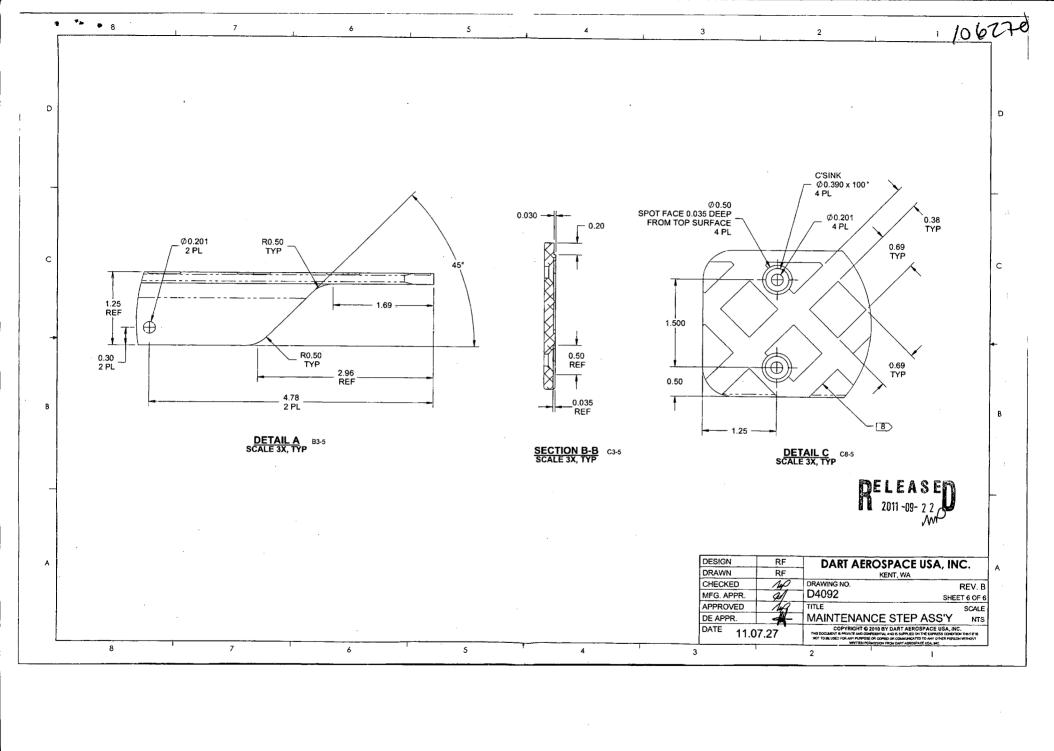
Wave/Twist in Tube

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			DQA:	Date:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	<del></del>	
			QA Closed:	Date:

											QA Clo	sed: [	Date:		
Work Ord	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part I	No.					Rework Scrap Use-as-is Work Order Update			Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other	
Root		Descri		iption of work order update		nitial	Action		Sign	&					
Cause		Date	Step	Qty	(	or Non-conformance		ief Eng	ing Description		Date	e Verificat	ion	QC Inspector	
Doc/Data										-		. `		4	
Equip/Tooling													1		
Operator			ł												
Material					٠			•							
Setup															
Other														•	
Process															
Supplier															
Training	<u> </u>													•	
Unapproved		<u> </u>													
							AUL	T CATE	GORY					·	
Landi	ng (	1	*			General	_	ı			_				
	<u> </u>	Bending			_	Bend	-	Grain		Ovalized			Pressure/Forced		
	<u> </u>	Centre Not Concentric to O/S				BOM/Route	-	Hardwa	<del> -</del>		Over/Under tolerance			Temperature/Cure	
	<u> </u>	Cracks				Broken/Damaged	-	1	pection Incomplete		Part Incorrect			Weld	
		Crushed/	Crimped		_	Burrs		i .	ions Incomplete/	Unclear	<b>⊣</b>	t/Missing	Ш	Wrong Stock Pulled	
	<u> </u>	Cuffs				Contamination	$\vdash$	Maintenance			Part Mo				
	<u></u>	Heat Trea			<u> </u>	Countersink		Mislabeled			<b>⊣</b>	ed Wrong			
		Inspection	•	Tube	<u> </u>	Cut Too Short		Misread	<b>d</b> .		Power L	oss/Surge		Other	
	<u></u>	Ripples in				Drill Holes		Offset							
	$\vdash$	Torque W			n L	Drawing	<u></u>	1	Calibration						
		Turning S			L	Finish	$\vdash$	Out of Sequence							
	1_	Wave/Tw	ist in Tub	oe		Folio		Outside Dimensions							



										- "A-	DQA:	Dat	le:	
NCR:	Yes	/ No				WORK ORDER NON-	100	NFOR	MANCE / UPDAT		OA Classel			
								<del></del>	`		QA Closed:	Dat	e:	
Work Order:						DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Work Order.						Rework	Skid-tube Crosstube			Water Jet			Engineering	
Part I	Vα					Scrap				Prod. Eng. Coor.			Quality	
	_					Use-as-is				<b>—</b>	Rec/Store/Packaging			Other
NCR I	No.					Work Order Update					Supplier			
	_						٠ ا				l			
Root					Descri	ption of work order update	$\sqcap$	Initial	Action		Sign &			
Cause	-	Date	Step	Qty	,	or Non-conformance	Ch	nief Eng	Description	n	Date	Verification	1	QC Inspector
Doc/Data														
Equip/Tooling														
Operator	П		:											
Material														
Setup	П				İ									
Other	П				İ									
Process														
Supplier														
Training														
Unapproved														
						F	AUL	T CATE	GORY					
Landi	ng Ge	ear				General	_	_			1	-		
	L	Bending				Bend	Grain	Grain			<u> </u>	Pr	essure/Forced	
	Ш	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	ardware		Over/Under	tolerance	Te	mperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct [	w	eld
		Crushed/0	Crimped			Burrs		Instruct	ions Incomplete/Unclea	ar 🔙	Part Lost/Mi	ssing	w	rong Stock Pulled
	Cuffs					Contamination		Mainte	enance		Part Moved			

Mislabeled

Out of Calibration

Outside Dimensions

Out of Sequence

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

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